

Work Order ID 64135

November 25, 2010 11:44:07 AM



Page 1

Item ID: D4294-1



Revision ID: PRELIM

Item Name: Fitting

Start Date: 11/25/10 Start Qty: 2.00

Required Date: 11/30/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:  Date:
QC:  Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4294

PA2

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank to 7.125"

Batch: M116153

0.00

0.00

OK 10/11/30

2 0

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB008

DWG REV: PA2

FOLIO REV: AA

2- deburr rough edges

0.00

0.00

OK 10/12/01

10/12/01

2 0

Work Order ID 64135

November 25, 2010 11:44:08 AM

Page 2

Item ID: D4294-1

Revision ID: PRELIM

Item Name: Fitting

Start Date: 11/25/10 Start Qty: 2.00

Required Date: 11/30/10 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

amk 10/12/01

2

5

Quality Control

AD 10/12/01

2

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

*- inspect to P22
Dm only*

8.10.12.02



Quality Control

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

- AD 10/12/0

2

Hand Finishing

Work Order ID 64135

November 25, 2010 11:44:08 AM



Page 3

Item ID: D4294-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fitting

Start Date: 11/25/10

Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M115951

Memo

0.00

Powder Coating

START 8:50
QUNT. 3000
FINISH 9:20

2 Bl 10-12-2

150

QC3- Inspect Part Finish

0.00



QC

Memo

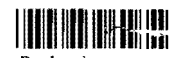
0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

pull on
w/o.
#64199

MF
10-12-02

Work Order ID 64135

November 25, 2010 11:44:08 AM



Page 4

Item ID: D4294-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Fitting

Start Date: 11/25/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

pulled on.
#64199.

MF
10-12-02

Picklist Print

November 25, 2010 11:44:06 AM

Page 1

Work Order ID: 64135

Parent Item: D4294-1

Parent Item Name: Fitting



Start Date: 11/25/10

Required Date: 11/30/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-25 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B4.000x4.00 0		Purchased	No			100	f	4.9105	0.6	1.263158			



7075-T73 Bar 4.0 x 4.0

Location

Loc Qty

Loc Code

MAT

4.9105

116153

4.9105

1.263 *am 10/11/30*

DART AEROSPACE LTD		Work Order: 64135
Description: FITTING		Part Number: D4294-1
Inspection Dwg: D4292 Rev: PA2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.065	$\pm .010$.065	—		Vern	ML-7
R.063	$\pm .010$	R.065	—		Rad-gage	REF
.305	$\pm .030$ $\pm .010$.308	—		Vern	ML-7
3.11	$\pm .030$	3.115	—		"	"
.325	$\pm .010$.325	—		"	"
.76	$\pm .030$.756	—		"	"
.80	$\pm .030$.800	—		"	"
1.54	$\pm .030$	1.541	—		"	"
.500	$\pm .010$.491	—		"	"
.070	$\pm .010$.070	—		"	"
.39	$\pm .030$.392	—		"	"
.500	$\pm .010$.500	—		"	"
.88	$\pm .030$.878	—		"	"
.764	$\pm .010$.767	—		RA26	
3.44	$\pm .030$	3.441	—		Vern	ML-7
2.450	$\pm .010$	2.451	—		"	"
2.04	$\pm .030$	2.050	—		"	"
1.528	$\pm .010$	1.531	—		"	"
.300	$\pm .010$.302	—		"	"
.738	$\pm .010$.741	—		"	"
.25	$\pm .030$.249	—		"	"
3.375	$\pm .010$	3.375	—		High-gage	31006
4.875	$\pm .010$	4.874	—		Vern	ML-7

Measured by: <i>mf</i>	Audited by: <i>S</i>	Preliminary Approval:		
Date: 10/12/01	Date: 10/10/01	Date:		
10/12/01 inspection to PA2 Dwg				
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order: 64135
Description: Fitting		Part Number: D4294-1
Inspection Dwg: D4292 Rev: PA2		Page 1 of 1

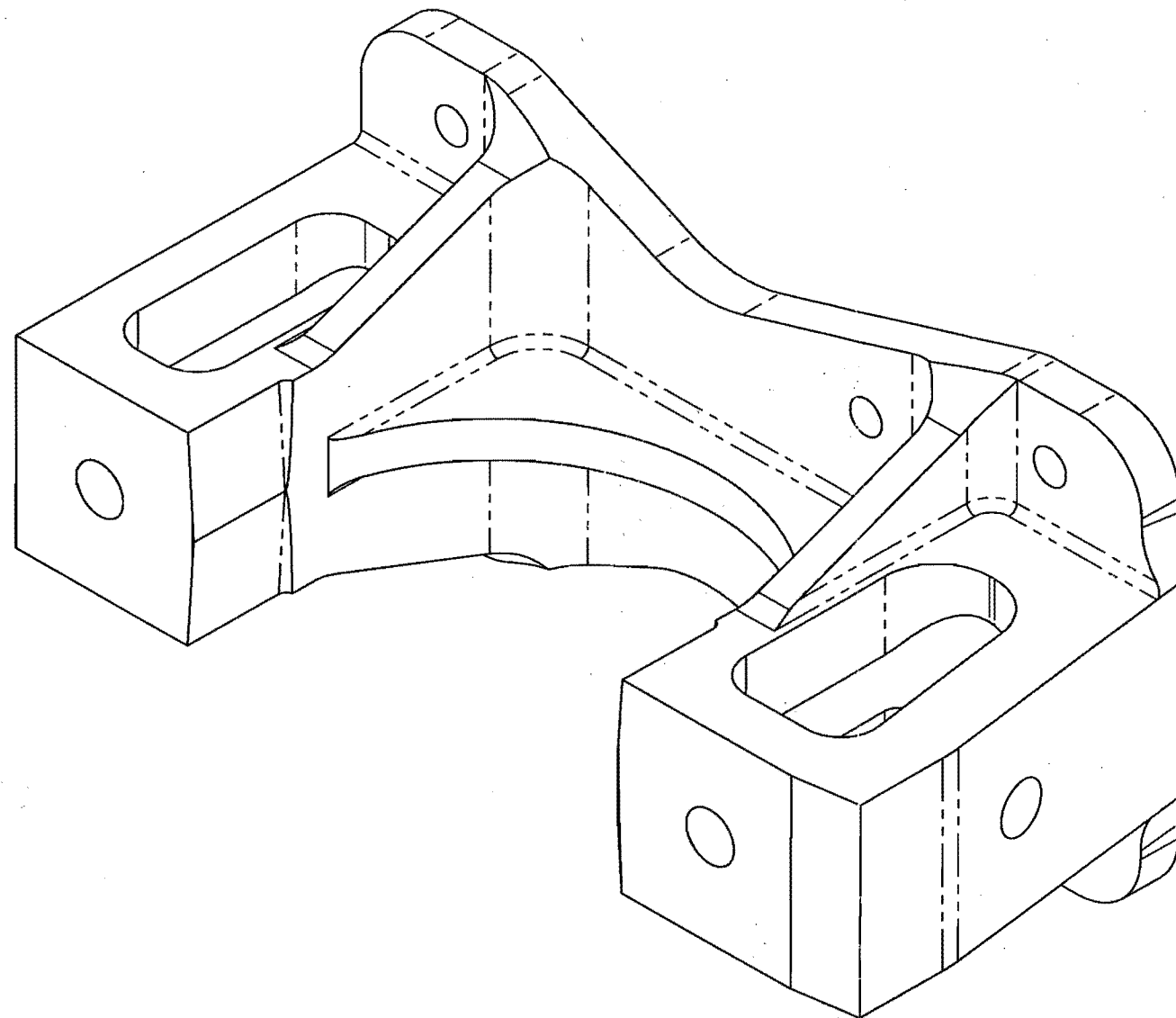
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.670	$\pm .010$	1.668	—		Vern	ML-7
$\phi .386$	$\pm .006$	$\phi .387$	—		"	"
$\phi .266$	$\pm .006$	$\phi .267$	—		"	"
6.81	$\pm .030$	6.808	—		Vern	CNC-02
6.35	$\pm .030$	6.350	—		"	"
1.46	$\pm .036$	1.454	—		Vern	ML-7
3.440	$\pm .016$	3.441	—		"	"
$\phi .875$	$\pm .010$	$\phi .880$	—		"	"
$\phi .750$	$\pm .010$	$\phi .750$	—		"	"
6.49	$\pm .030$	6.490	—		Vern	CNC-02
.332	$\pm .020$.336	—		Micro	ML-01
.691	$\pm .016$.692	—		Vern	ML-7
4.968	$\pm .010$	4.966	—		"	"
8°	$\pm 1/2^\circ$	8°	—		Comb-square	ML-CBB
1.405	$\pm .010$	1.402	—		RA26	Vernier
$\phi .381$	$\pm .006$.381	—		"	
R.13	$\pm .030$	R.130	—		Rad-gage	REF
.64	$\pm .030$.636	—		Vern	ML-7
R1.760	$\pm .010$	R1.755	—		Height-gage	31006

Measured by: <i>mf</i>	Audited by: <i>S</i>	Preliminary Approval:
Date: 10/12/01	Date: 10/12/01	Date:
inspected to PA2 Dwg		

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



D4294-1 FITTING

PRELIMINARY ISSUE

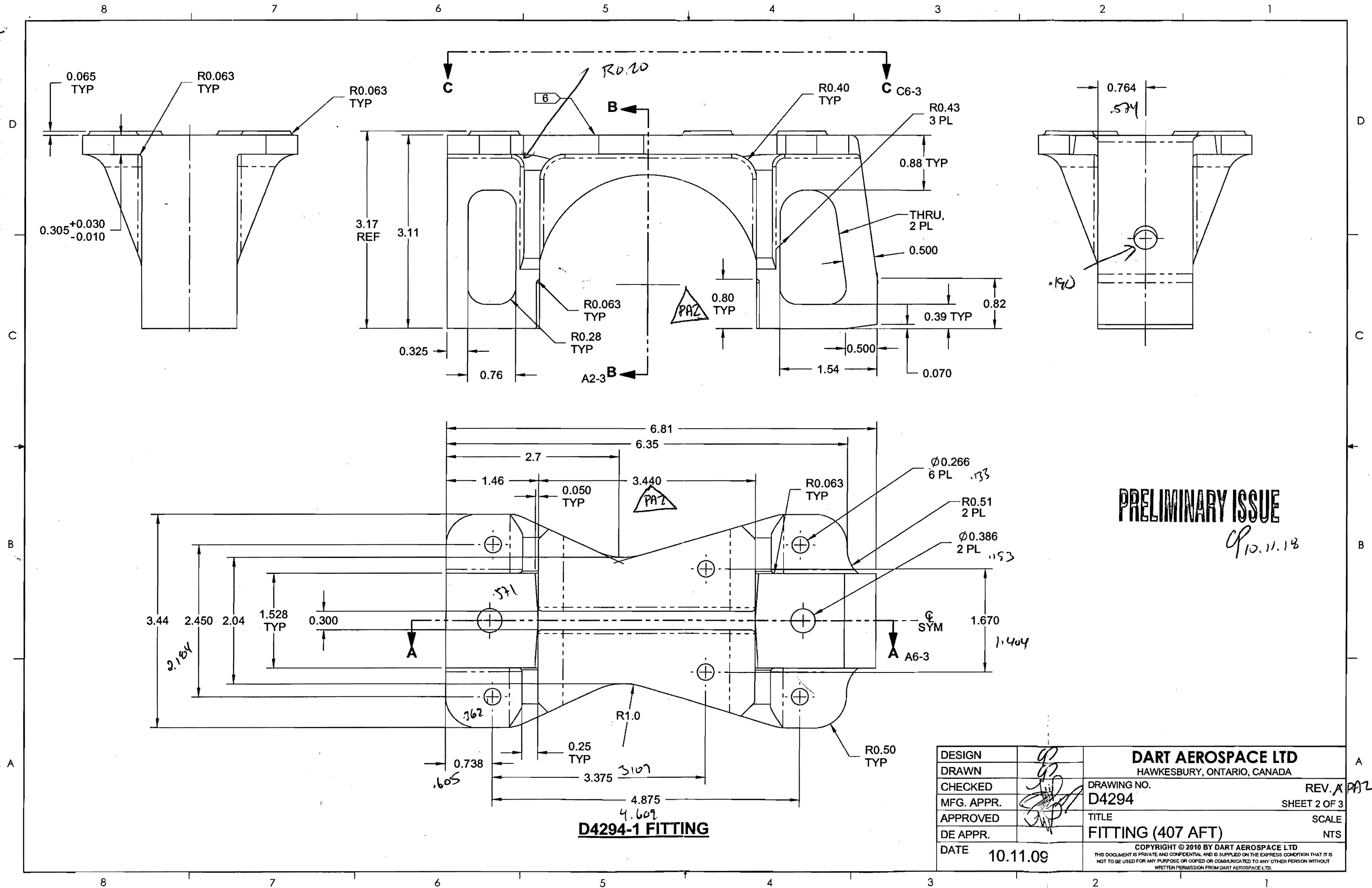
Rev PAZ

10.11.18

NOTES:

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.56 lbs

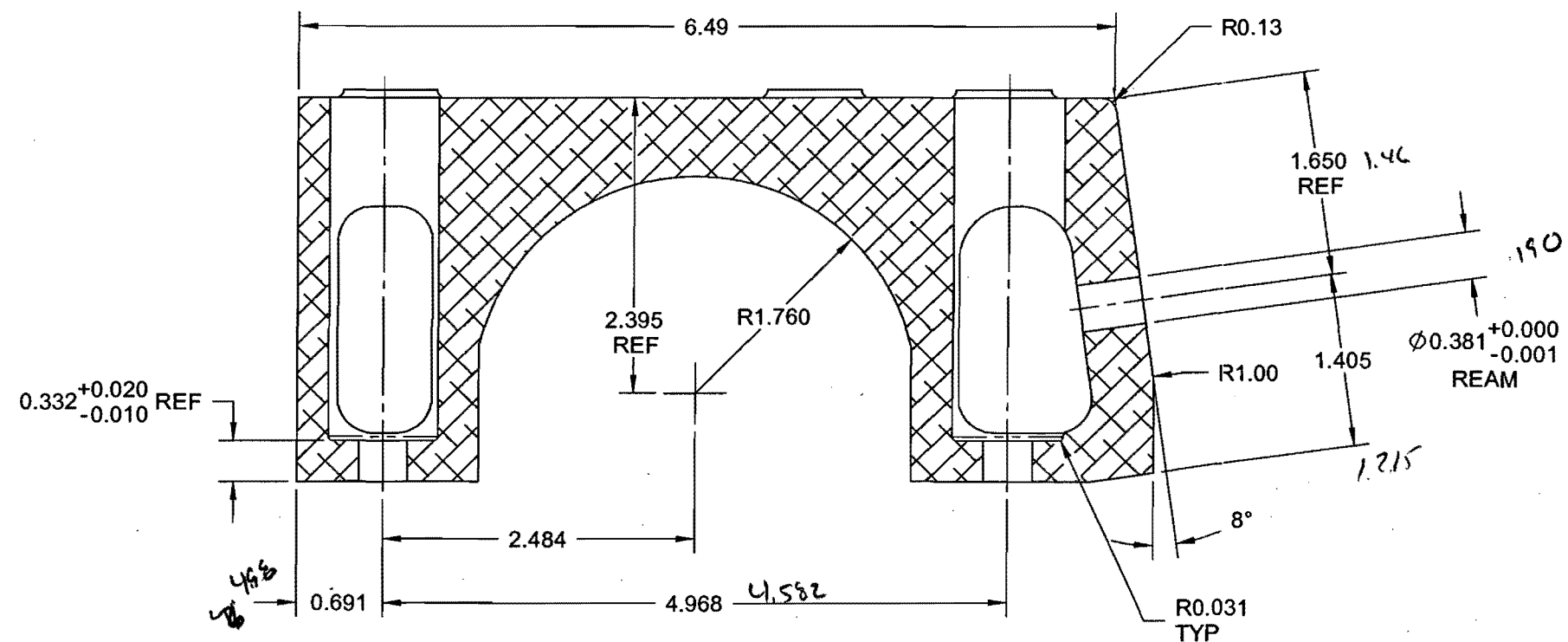
PAZ	ADD CUT OUT, ADD 3.440 DIM	CP	10.11.18
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4294	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (407 AFT)	NTS
DATE	10.11.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



C'BORE $\varnothing 0.875$
LEAVE $0.332^{+0.020}_{-0.010}$
(SEE SECTION A-A)
2 PL

$\varnothing 0.750$
6 PL

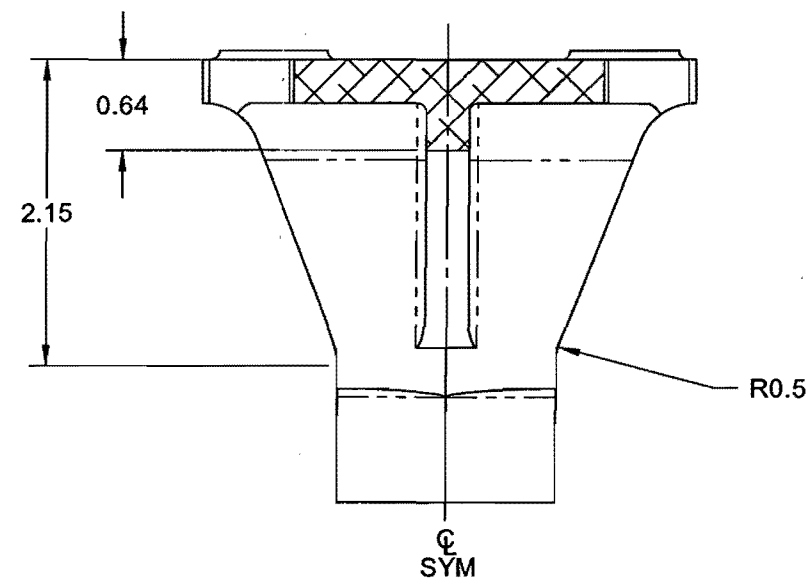
SECTION C-C D3-2



SECTION A-A A3-2

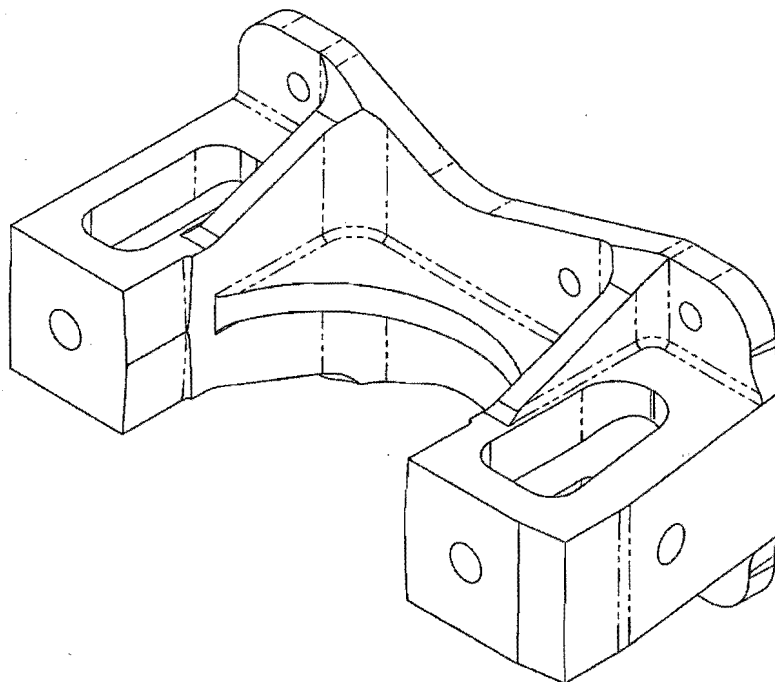
PRELIMINARY ISSUE

P10-11.1B



SECTION B-B C5-2

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4294	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (407 AFT)	NTS
DATE	10.11.09	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

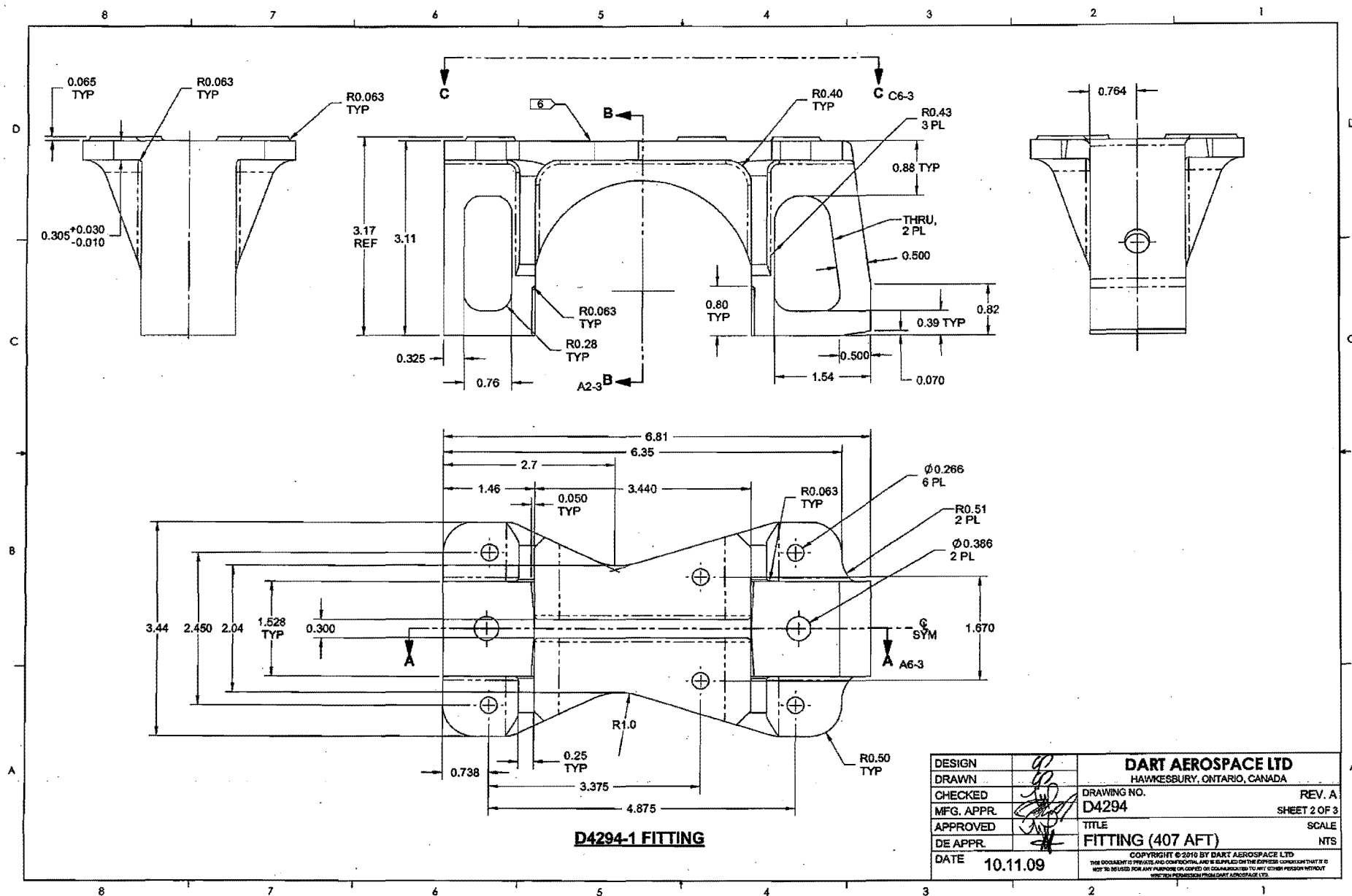


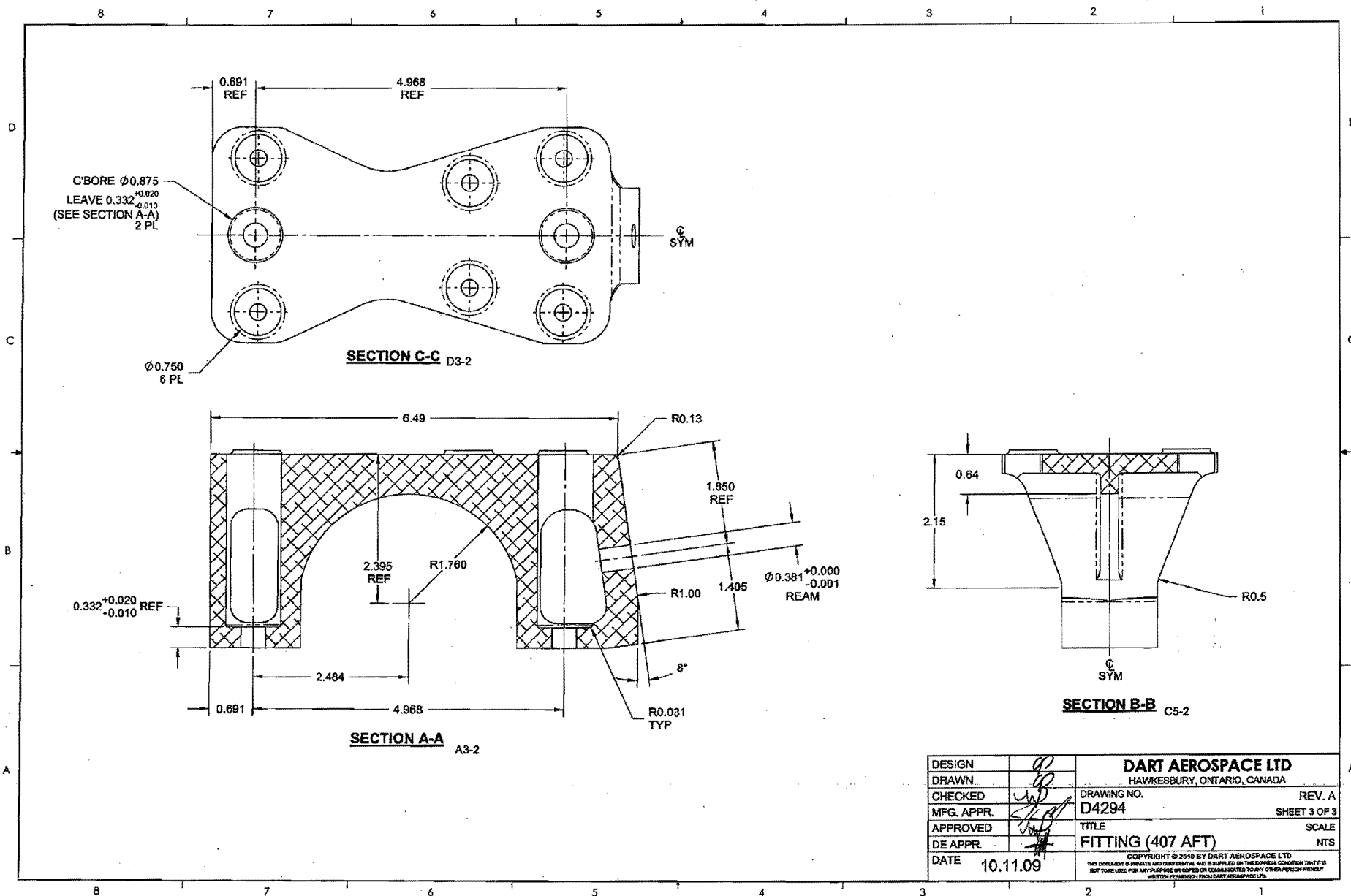
D4294-1 FITTING

NOTES:

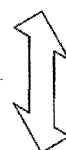
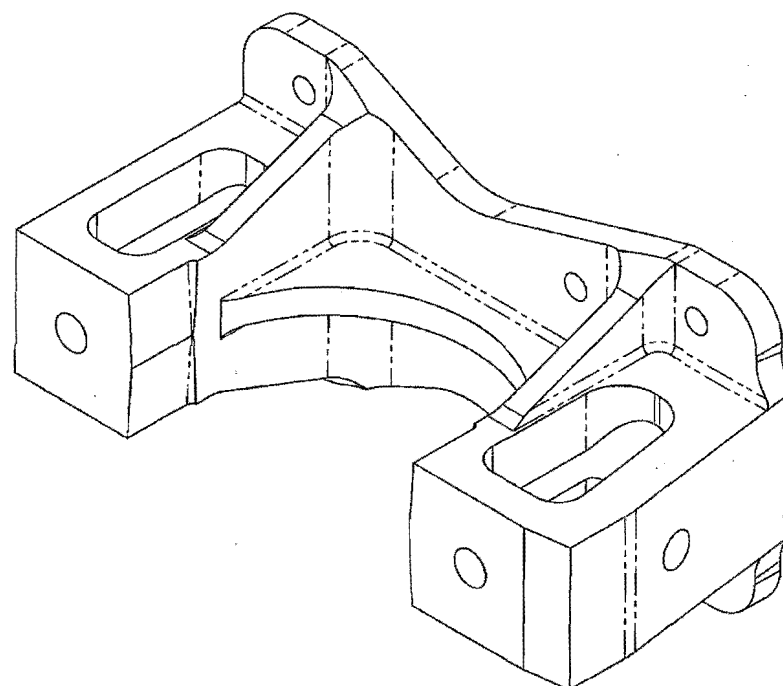
- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.56 lbs

A		NEW ISSUE		CP	10.11.09
REV.	DESCRIPTION			BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4294 TITLE FITTING (407 AFT) COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			REV. A	
DRAWN				SHEET 1 OF 3	
CHECKED				SCALE	
MFG. APPR.				NTS	
APPROVED					
DE APPR.					
DATE	10.11.09				





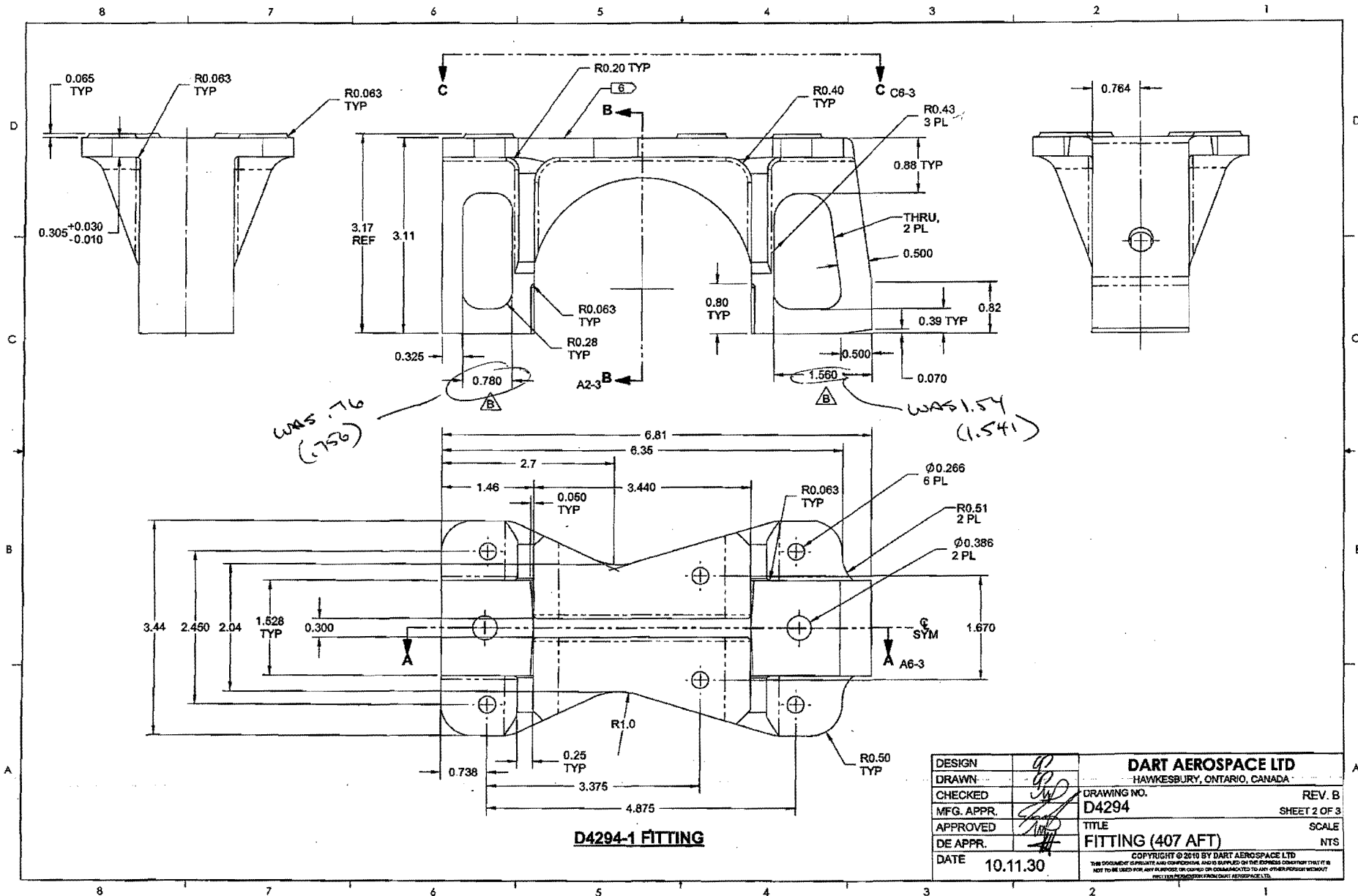
64135

GRAIN
DIRECTION**D4294-1 FITTING****NOTES:**

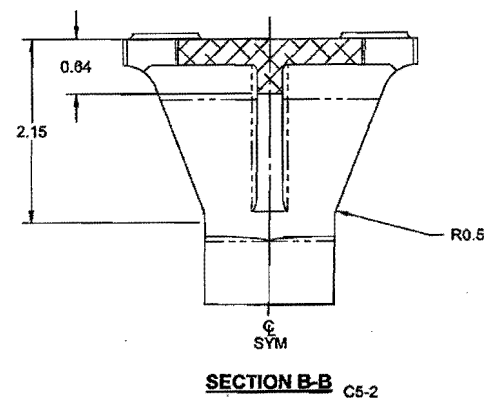
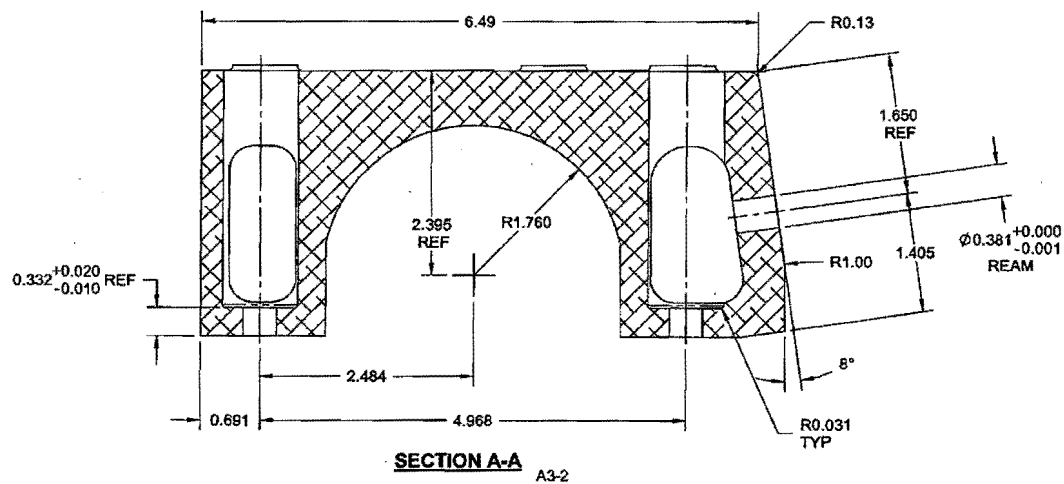
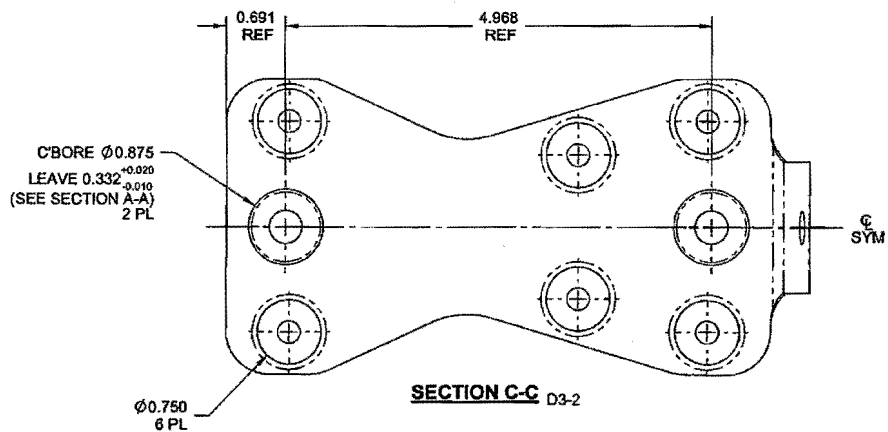
- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4294-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.55 lbs

B	0.780 WAS 0.78 (C6-2), 1.560 WAS 1.54 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.30		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. B	
D4294		SHEET 1 OF 3	
TITLE		SCALE	
FITTING (407 AFT)		NTS	
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION FROM DART AEROSPACE LTD.			

64135



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4294	REV. B
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE FITTING (407 AFT)	SCALE
DE APPR.			NTS
DATE	10.11.30	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR IN ANY MANNER OR DISSEMINATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4294	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FITTING (407 AFT)	NTS
DATE	10.11.30	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED TO THE PUBLIC ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGIN OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	